

Date: Wednesday, 1/31/2007 2:59:21 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 30538  
 Estimate Number : 12579  
 P.O. Number : N/A  
 This Issue : 1/31/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : SMALL / MED FAB  
 Previous Run : 29448  
 Written By : Jan  
 Checked & Approved By : 07.02.01  
 Comment : Est Rev:A New Issue 06-11-10 JLM

Drawing Name : ARM

Part Number : D35602  
 Drawing Number : D3560 UNDER REVIEW  
 Project Number : N/A  
 Drawing Revision : A  
 Material : N/A  
 Due Date : 2/7/2007

Qty: 5 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

1.0 M6061T6B0500X06000 6061-T6



Comment: Qty.: 1 f(s)/Unit Total: 5 f(s)

6061-T6 Bar .50" x 6.0"

Batch: 07.03.07

2.0 WATER JET FLOW W/



Comment: FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: AProg Rev: A

2-Deburr if necessary

Note: .507" Dia &amp; .196" Dia Holes are to be opened on manual mill after Waterjet

3.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE

mm 07 03 12  
mm 07 03 07



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-Open .196" Dia hole

2-C'Bore as per Dwg D3560.

3-Ream .507" as per Dwg D3560






\*\*\*Ensure to C'Bore on Corect side\*\*\*

86 / DJP 07/03/08 07.03.07

~~with weight~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D356A-2 <sup>NIA</sup> PAR #: NIA Fault Category: Prod / FMS <sup>NIA</sup> ~~mod & SMT~~ NCR: Yes ~~No~~ DQA: 2 Date: 07/03/03  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 30538		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/08	4.0	4 parts scrap C"bore 0.507" is over tol. by 0.006" Can't press fit bushing		-destroy 4 parts  -When doing the FAI you need to write the demension your measure (not acceptable)	 07/03/09	 07/03/09	 07/03/08	 07/03/08
				-replace 4 parts -IF FAI is not good dont to the other parts				

NOTE: Date & initial all entries

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Drawing Name: ARM

Job Number: 30538

Part Number: D35602

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.03.20

(4)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07.03.20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WAS*

07.03.20

4

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/23

(4)

Job Completion



07-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

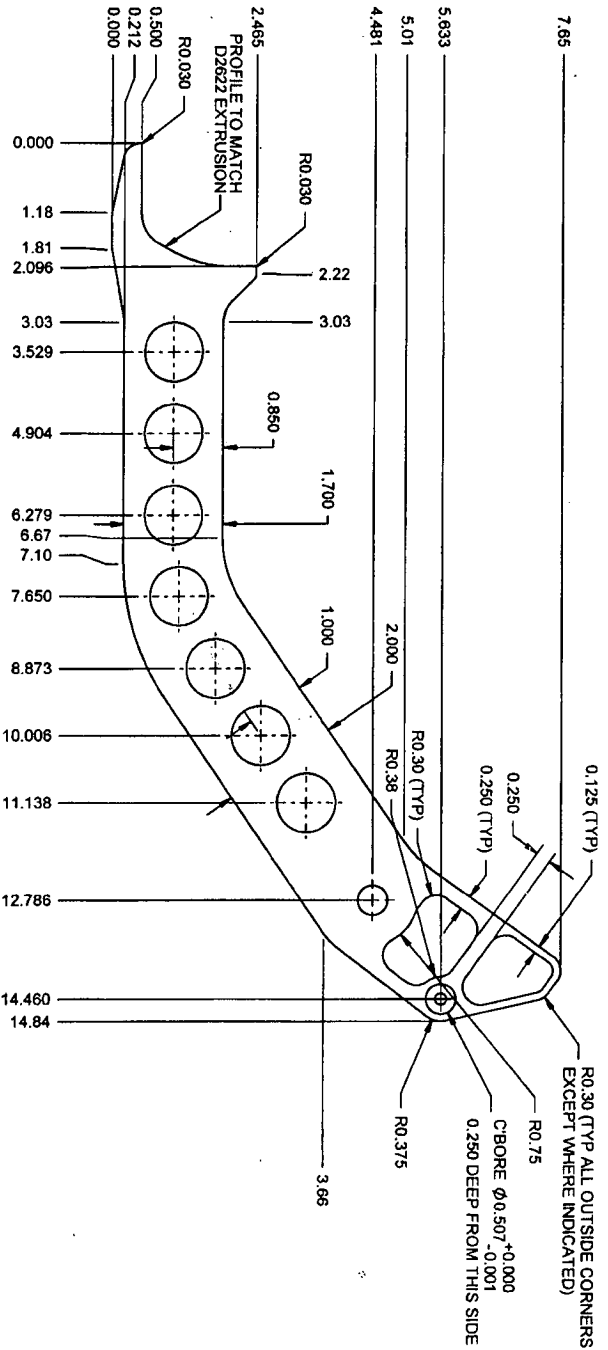
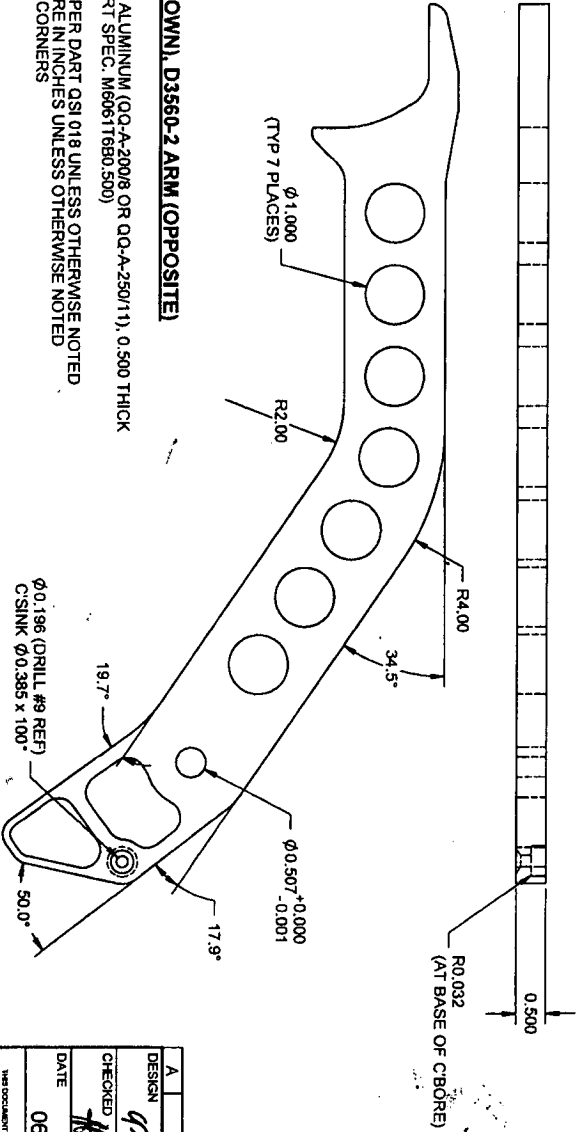
NOTE: Date & initial all entries

NO. 30538  
 WORK OFFICE  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 UNCONTROLLED COPY  
 RETURN TO  
 SHOP COPY

**D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)**

- NOTES:  
 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11), 0.500 THICK  
 (REF. DART SPEC. M6061T6B0.500)  
 2) FINISH: NONE  
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
 5) BREAK ALL SHARP CORNERS

Ø0.196 (DRILL #9 REF)  
 C SINK Ø0.385 x 100°



A	06.09.25	NEW ISSUE
DESIGN	qj	DART AEROSPACE LTD
CHECKED	qj	HAWKESBURY, ONTARIO, CANADA
DATE	06.09.25	REV. A
TITLE	ARM	SHEET 1 OF 2
SCALE	12	

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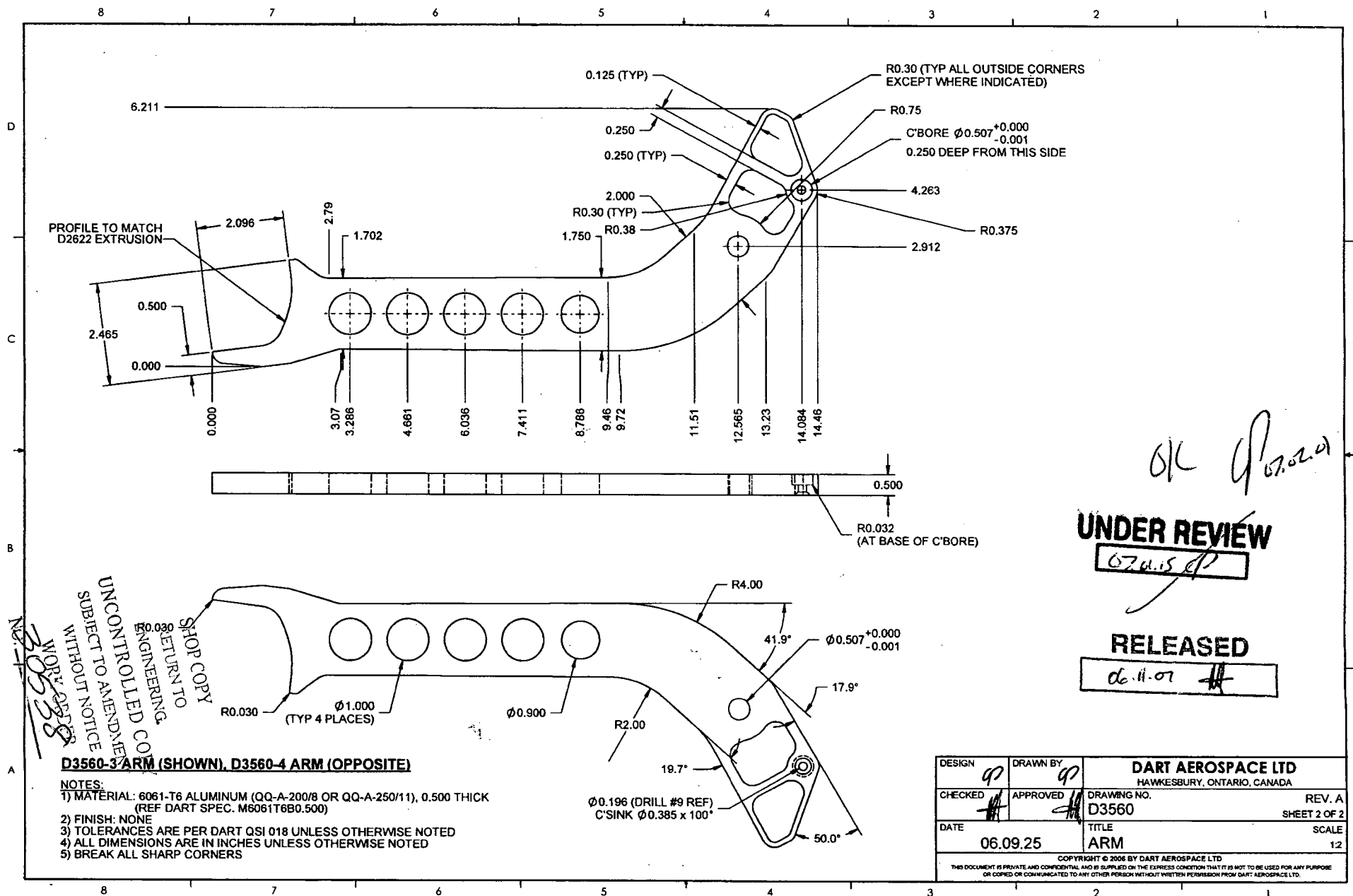
**RELEASED**  
 06.11.07

**UNDER REVIEW**

07.01.08

OK  
 07.02.08





UNDER REVIEW

RELEASED

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30538
<b>Description:</b> ARM		<b>Part Number:</b> D3560-2
<b>Inspection Dwg:</b> D3560 . Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article     ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- 0.010	0.507	✓		vern	
2.465	+/- 0.010	2.468	✓		High Gauge	
0.250	+/- 0.010	0.255	✓		vern	
0.125	+/- 0.010	0.130	✓		vern	
1.000	+/- 0.010	1.005	✓		vern	
2.000	+/- 0.010	2.007	✓		vern	
1.700	+/- 0.010	1.707	✓		vern	
0.850	+/- 0.010	0.855	✓		vern	
0.507	+0.000 -0.001	0.507	✓			
0.250	+/- 0.010	0.252	✓			
0.385 x 100°	+/- 0.010	0.385	✓			
0.196	+0.005 -0.001	0.197	✓			
		0.513				

07/03/08

\* DIP 07/03/08  
 Measured by: *[Signature]*  
 Date: 07 03 07

Audited by: *[Signature]*  
 Date: 07-03-20

Prototype Approval:  
 Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



